

Date: Friday, 13/02/2009 2:39:59 PM
User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ADJUSTABLE ATTACHMENT ARM ASSY
Job Number :	45801		
Estimate Number :	13479		
P.O. Number :		Part Number :	PB674300159
This Issue :	13/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.14
First Issue :	/ /	Project Number :	N/A
Previous Run :	45024	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	20/02/2009
Written By :		Qty:	1
Checked & Approved By :	<u>YMF 09-02-13</u>	Um:	Each
Comment :	Est Rev:A 08-07-18 new issue DD verified by:ec Est Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified by: ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001113	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Square Tubing B45556
batch: B4477 = 1 X

SP 09.02.25

2.0	PB6743001119	End Cap Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
End Cap Clevis
batch: B4478 = 1 X

SP 09.02.25

3.0	PB6743001117	Hook Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hook Plate
batch: B41865 = 1 X

SP 09.02.25

4.0	PB6743001115	Tube End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Tube End Plate B24807
batch: B24087 = 1 X

SP 09.02.25

5.0	PB6743001271	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Doubler
batch: B41498 = 2 X

SP 09.02.25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total: 0.1575 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: 106551

SP 09.02.25

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

(1K)

SP 09.02.25

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.02.25 (U)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/25 (K)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mp/1K

(X1)

09/02/25

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

1:15

OVEN TEMPERATURE:

320°

FINISH TIME:

1:45

FL 09/03/03

(1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PK 09-03-3 (1)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Friday, 13/02/2009 2:40:00 PM
User: Melanie Fauteux

Process Sheet

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Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 45801

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001267

PB67-43001-267



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-267

batch: 41497

14.0

PB6743001121

Square Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Sleeve

batch: 1543329

15.0

BSP43

RIVET



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

RIVET

batch: 109119

16.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: 109031

17.0

30345T21

LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARD

batch: 17828

18.0

MS27039122

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: 18057

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: 1110399

9/3/3

SP

W/O:		WORK ORDER CHANGES						
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Job Number: 45801

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

batch: M18057

9/13/13

(16)

Sp

21.0

SMALL FAB

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

SAD

09-03-23

(1)

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/03/24 @

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

937A

PC9/3/24

(1)

24.0

QC21

FINAL INSPECTION/W/O RELEASE




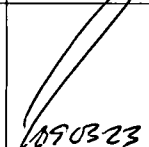
Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



mk
09-03-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector	
09-03-23	21.00	AN960 JD6 → <u>M6085</u> ADD WASHER TO RIVETS FOR PAD.	Qd	09-03-23	4			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
4-26-62

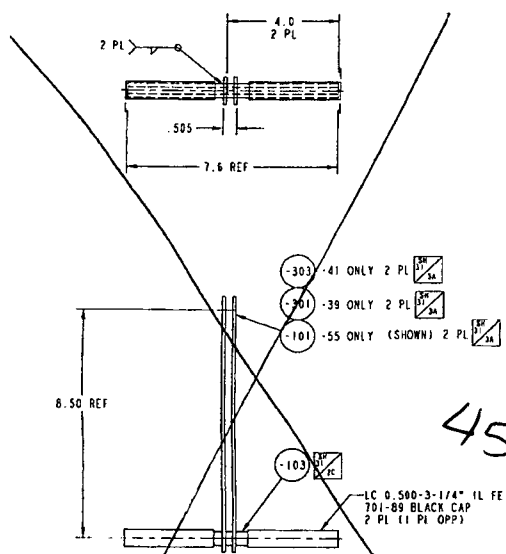
8 7 6 5 4 3 2 1

D

C

B

A

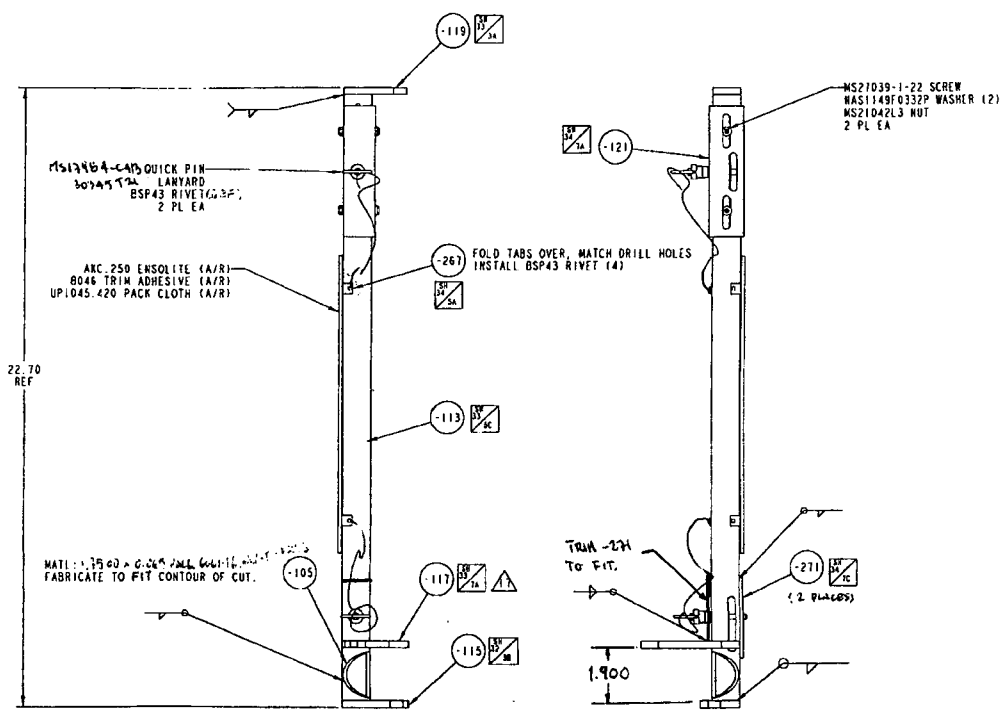


- ① -39 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ① -41 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ② -55 HANDLE AND LOCK-DOWN ASSEMBLY (SHOWN)

SCALE 0.500

SUPERCEDED BY
SUPERSEDED BY D5451-041/-043/-045/-047

45801



- ① -59 ADJUSTABLE ATTACHMENT ARM ASSY

SCALE 0.500

PREMIER AVIATION, INC.			
3001 Aviation Parkway, Grand Prairie, Texas 75051			
DATE	COMP. TOGET. NO.	REV.	REV.
01/05/81	B67-43001	81	
SCALE:	REV:	SHEET	14 OF 45

ORIGINAL

8 7 6 5 4 3 2 1

D

C

B

A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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